

Date: Tuesday, 15/08/2006 7:44:07 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	WEARPAD
<b>Job Number</b> :	28123		
<b>Estimate Number</b> :	10313		
<b>P.O. Number</b> :		<b>Part Number</b> :	D26483
<b>This Issue</b> :	15/08/2006	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2648 REV D
<b>First Issue</b> :	10/08/2006	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	27169	<b>Drawing Revision</b> :	D
		<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	30/08/2006
<b>Checked &amp; Approved By</b> :		<b>Qty:</b>	100
<b>Comment</b> :	Est: E 02.09.18 Re-format, incorporated D2648-1 KJ/RF		

Um: Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0.	M1010S16GA	1010/1025/A21/6aA SHEET
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Batch # ~~M1010S16GA~~ M101463



**Comment:** Qty.: 0.0750 sf(s)/Unit Total: 7.5000 sf(s)  
 1010/1025/A21/6aA SHEET

M 06 08 17

2.0	WATER JET	FLOW WATER JET
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B Dw P  
 Prog D



**Comment:** FLOW WATER JET

M 06 08 17

(100)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

M 06 08 17

(100)

4.0	QC8	SECOND CHECK
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**Comment:** DIMENSIONAL CHECK

06-08-20  
 count (100)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
 Deburr if necessary

M 06/08/23

6.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.  
 2-Identify as D2648-3

SB 06/08/29 (100)

Date: Tuesday, 15/08/2006 7:44:08 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 28123

Part Number: D26483

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch

A/R560Hardcoat

M100786 M100294

1-Weld as per Dwg D2648 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

PC 06-09-01

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 06-09-01 (100)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 06-09-01 (100)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M14720

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FC 06 10 12 100

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m 06/10/13 (100)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FPI7

FC 06 10 13 (100)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

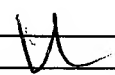

Job Completion



U 06-10-13

Date: Thursday, 10/08/2006 10:01:11 AM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : WEARPAD
<b>Job Number</b> : 28123	
<b>Estimate Number</b> : 10313	
<b>P.O. Number</b> :	<b>Part Number</b> : D26483
<b>This Issue</b> : 10/08/2006 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2648 REV D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : D
<b>Previous Run</b> : 27169	<b>Material</b> :
<b>Written By</b> : 	<b>Due Date</b> : 30/08/2006 <b>Qty:</b> 100 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : 	
<b>Comment</b> : Est: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: \_\_\_\_\_  
Email or ship DXF file to vendor  
Make per Drawing D2648-1  
Material release note required

*M1010S166A  
075 SF*

*Waterjet*

*M1010463*

*M 06 08 17 (100)*

2.0	D26483F	Wearpad
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)  
WEARPAD

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage  
Ensure material release note is attached

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
Deburr if necessary

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 10/08/2006 10:01:11 AM  
User: Linda Lacelle

## Process Sheet

1

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 28123

Part Number: D26483

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326

2-Identify as D2648-3

7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Qty	Description	Batch
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A/R 560 Hardcoat

1-Weld as per Dwg D2648 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

8.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

10.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/08/2006 10:01:12 AM  
User: Linda Lacelle

## Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services

**Drawing Name:** WEARPAD

**Job Number:** 28123

**Part Number:** D26483

Job Number:



**Seq. #:**

**Machine Or Operation:**

**Description :**

13.0

DC

DOCUMENT CONTROL



**Comment:** DOCUMENT CONTROL

Inspection Level 21

Job Completion



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

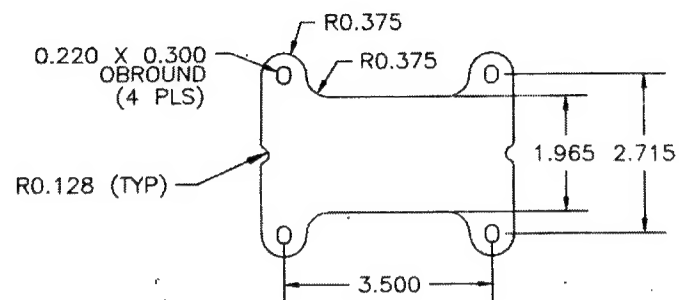
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

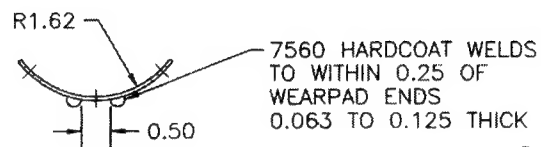
**NOTE:** Date & initial all entries



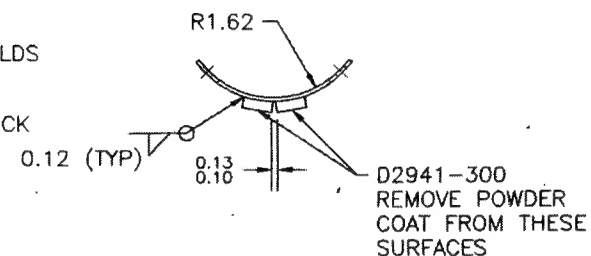
# D2648-1 FLAT PATTERN



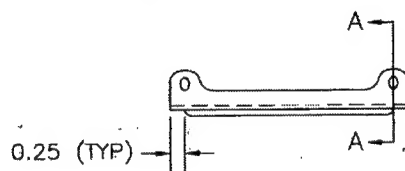
## SECTION A-A



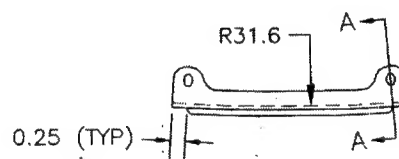
## SECTION B-B



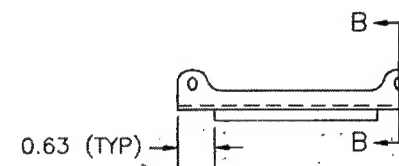
## D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)



## D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



## D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)



RELEASED  
1999.12.20 DS



BREAK ALL SHARP CORNERS 0.063 MAX  
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)  
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE OBOUND, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2648
DATE	99.11.17	TITLE WEARPAD
		REV. D SHEET 1 OF 1 SCALE 1:2

